

SHIP 10608

Dart Aerospace Ltd.

Date: Wednesday, 8/22/2007 9:58:21 AM
User: Kim Johnston

Process Sheet

37

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CO-PILOT KIT OPTION B
Job Number : 34204
Estimate Number : 12990
P.O. Number : N/A Part Number : P107B
This Issue : 8/22/2007 S.O. No. : N/A Drawing Number : GA122 REV A
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB Drawing Revision : N/A
Previous Run : 34073 Material : N/A
Written By : Due Date : 9/10/2007 Qty: 1 Um: Each
Checked & Approved By : 07.08.22
Comment : Est Rev.A New Issue 07-04-16 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 DC DOCUMENT CONTROL



07.08.30 (1)

Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP P107B

Chg 001

J 07-08-18

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 G10202 CYCLIC STICK



eps

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CYCLIC STICK

Batch: 234117

4.0 G10201 Collective Stick



eps

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Collective Stick

Batch: M105124

5.0 133159 CLIP



eps

Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

CLIP

Batch: M105124

07/08/27 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 8/22/2007 9:58:21 AM
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Drawing Name: CO-PILOT KIT OPTION B

Job Number: 34204

Part Number: P107B

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

332A27 2114 21

BOOT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BOOT
Batch: M105124

EP



7.0

3410 14

Split Ring



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Split Ring
Batch: ~~M105124~~ M105619

EP



8.0

341A27 1368 20W

BOOT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BOOT
Batch: M105124

EP



9.0

350A27 1185 00

PEDAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
PEDAL
Batch: M105124

EP



10.0

350A27 1185 01

PEDAL, DIRECTIONAL CONTROL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
PEDAL, DIRECTIONAL CONTROL
Batch: M105124

EP



11.0

350A27 1328 01

PLATE, BOOT MOUNT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
PLATE, BOOT MOUNT
Batch: M103779

EP



12.0

350A27 1340 20

COPILOT GRIP ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
COPILOT GRIP ASSEMBLY
Batch: M105124

EP



EP 07/08/27 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

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Drawing Name: CO-PILOT KIT OPTION B

Job Number: 34204

Part Number: P107B

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

350A27 1397 00

COVER, PITCH STICK



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
COVER, PITCH STICK
Batch: M105124

CP



14.0

350A27 1525 0101

COLLERETTE FLANGE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
COLLERETTE FLANGE
Batch: M105124

CP



15.0

350A27 1528 0101

SHIM



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
SHIM 1.0
Batch: M103779

CP



16.0

A0023CQ6R35NW

PIN, LOCKING



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
PIN, LOCKING
Batch: M105124

CP



17.0

ASNA0033 045

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Clamp
Batch: M105124

CP



18.0

MS3116E20 41P

Connector, 41 pin



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Connector, 41 pin
Batch: M105124

CP



19.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

JA05-18
re-check JA05-21
JA05-18
JA05-21



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/09/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Seq. #:

Machine Or Operation:

Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP P107

Location:

PPP Rev:

DRAFT

P-27/18

(U)

21.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

DRAFT 9/21

Job Completion



U 07-09-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

Qty -011A	Qty -011B	Qty -013	Qty -015	Qty -017	Qty -019	Dart P/N	Geneva P/N	Description
X				1		D350-771-011A	P111-P	PILOT CYCLIC GRIP KIT
	X		1	1		D350-771-011B	P111-C	CO-PILOT CYCLIC GRIP KIT
		X	1	1		D350-771-013	OPTION B	CO-PILOT (FACTORY STD) KIT
			X			D350-771-015	OPTION C	CO-PILOT (DART) KIT
				X		D350-771-017	OPTION D	PILOT AND CO-PILOT CYCLIC GRIP WITH CO-PILOT STICKS KIT
					X	D350-771-019	OPTION E	COLLECTIVE SWITCH BOX KIT
		1				D3630-041	G10202	CYCLIC STICK
1						D3633-1	G10203	PILOT EXTENSION
	1					D3633-3	G10205	CO-PILOT EXTENSION
		1			1	D3634-041	G10201	COLLECTIVE CONTROL STICK
1	1					D3653-041	G10204	CYCLIC CONTROL HAND GRIP
*1	*1					*0645730	N/A	HAND GRIP
*1	*1					*7205	N/A	TRIGGER SWITCH (MOMENTARY)
*2	*2					*AN364-1032A	N/A	NUT
*1	*1					*AN500-6-24	N/A	SCREW
*1	*1					*AN526-10-22	N/A	SCREW
*1	*1					*AN526-10-24	N/A	SCREW
					1	350A27-1375-20	N/A	SCREW
					1	350A27-1376-20	N/A	SOCKET
					1	D3632-041	G10207	COLLECTIVE SWITCH BOX ASSEMBLY
					**1	**D3632-1	N/A	COLLECTIVE SWITCH BOX
					**1	**D3632-3	N/A	COVER PLATE
					**6	**MS21209-F0420	N/A	HELI-COIL
					**6	**MS24693-202B	N/A	SCREW
		10				133159	N/A	CLIP
		1				332A27-2114-21	N/A	BOOT, CYCLIC (OR 332A27-2114-20)
		4				3410-14	N/A	SPLIT RING
		1				341A27-1368-20W	N/A	BOOT, COLLECTIVE
		1				350A27-1185-00	N/A	PEDAL (OR 350A27-1185-20)
		1				350A27-1185-01	N/A	PEDAL (OR 350A27-1185-21)
		1				350A27-1328-01	N/A	PLATE, BOOT MOUNT (OR 350A27-1328-0151)
		1				350A27-1340-20	N/A	COLLECTIVE HANDLE
		1				350A27-1397-00	N/A	COVER, COLLECTIVE PITCH STICK (OR 350A27-1374-00 OR 350A27-1374-20)
		1				350A27-1525-21	N/A	FLANGE, CYCLIC (OR 350A27-1525-0101)
		1				350A27-1528-20	N/A	SHIM (OR 350A27-1528-0101)
		4				A0023C06R35N-W	N/A	PIN, LOCKING (OR 55701C06R35N-W)
		1				ASNA0033-045	N/A	CLAMP (5520-025-045)
		1				MS3116E20-41P	N/A	CONNECTOR, 41 PIN (OR PT06E14-19P)

* REFERENCE ONLY. PARTS ARE INCLUDED IN D3653-041

** REFERENCE ONLY. PARTS ARE INCLUDED IN D3632-041

REFERENCE ONLY

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Revision: A

Date: 07.06.25

WORK ORDER
 NO 34204